

Fire Red

Dart Aerospace Ltd.

Date: Tuesday, 21/04/2009 4:01:08 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PEDAL LOCK BASE
 Job Number : 47345
 Estimate Number : 11361
 P.O. Number :
 This Issue : 21/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D33703
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3370 REV.C
 Previous Run : 45792 Project Number : N/A
 Material :
 Due Date : 10/05/2009 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : JUD 09-04-21
 Comment : Est. B 05.05.25 Added Powder Coat KJ/JLM
 Est Rev:C 08-07-17 revC as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X02500 6061-T6 Bar 1.50 x 2.50



Comment: Qty.: 0.3657 f(s)/Unit Total: 2.1943 f(s)
 6061-T6 Bar 1.5" x 2.5"
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6B1.500x02.500)
 Identify for D3370-3
 Batch: 4100947

mk 09/04/22

⑥

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank: 1.500" x 2.500" x 4.120" long

mk 09/04/22

⑥

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine D3370-3 as per Folio FA482 and Dwg D3370
 Identify as D3370-3
 Dwg Rev: C

09/04/24

⑥ P40-2

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/04/24

⑥

5.0 QC8 SECOND CHECK








Comment: SECOND CHECK

09/04/24

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3370-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 09/08/06
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47345</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/23	3.0	Scrap 1 piece Broken Tap		Scrap & Replace 1 piece M100947	 09/04/23	 09-04-23	 09/04/23	 09/04/23

NOTE: Date & initial all entries

Date: Tuesday, 21/04/2009 4:01:08 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK BASE

Job Number: 47345

Part Number: D33703

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL

09-05-29

X6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

9:00

OVEN TEMPERATURE:

350°

FINISH TIME:

9:30

UMOI FS

09/05/01

X6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-01

X6

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST491

SS 09/05/01 X6

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04

Job Completion



mf 09-05-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47345
Description: Pedal Lock Cover		Part Number: D3370-3
Inspection Dwg: D3370	Rev: EC	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	3.997	✓			
3.344	+/-0.010	3.348	✓			
0.592	+/-0.010	.595	✓			
0.202	+/-0.010	.206	✓			
Ø1.000	+0.005/-0.000	1.000	✓			
0.25	+/-0.030	.254	✓			
0.283	+/-0.010	N/A				
2.000	+/-0.010	1.997	✓			
0.300	+/-0.010	.297	✓			
0.550	+/-0.010	.549	✓			
1.50	+/-0.030	1.494	✓			
Ø1.250	+0.005/-0.000	1.253	✓			
0.635	+/-0.010	.637	✓			
Ø0.750	+0.010/-0.000	.758	✓			
1.673	+/-0.010	1.672	✓			
0.430	+/-0.010	.428	✓			
2.638	+/-0.010	2.636	✓			
2.35	+/-0.030	2.347				
0.715 deep	+/-0.010	.713	✓			
15°	+/-0.1°	15°	✓			
0.19 x 45°	+/-0.030	.188 x 45°	✓			
0.450	+/-0.010	.451	✓			
1.450	+/-0.005	1.453	✓			

Measured by: Q	Audited by: SP	Prototype Approval:	N/A
Date: 09/04/24	Date: 09/04/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	

8 7 6 5 4 3 2 1

△

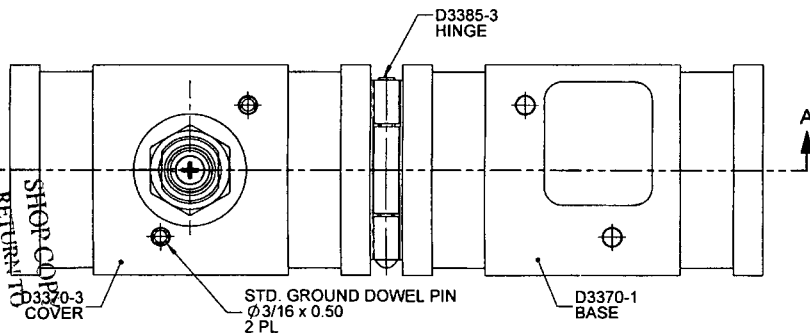
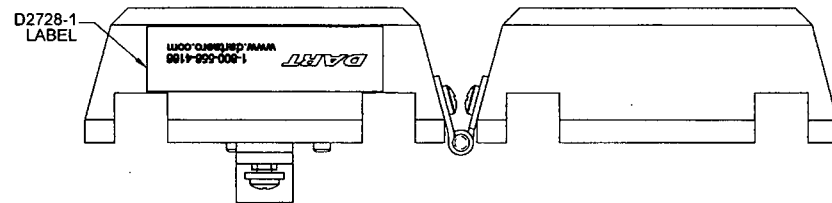
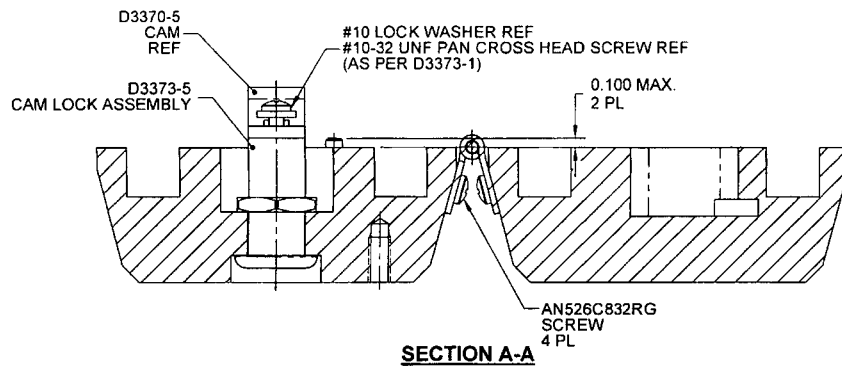
Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-416	WASHER
1		D2728-7	LABEL
1		D3370-1	BASE
1		D3370-3	COVER
1		D3373-5	CAM LOCK ASSY
1		D3385-3	HINGE
2		Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
4		AN528C832R6	SCREW

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08.07.11

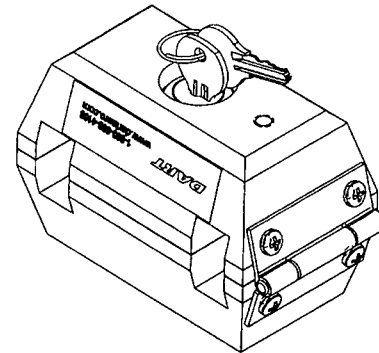
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C	SHEET 1 ADDED P/L. ADDED -041 TO P/L (SEE NCR 264). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.	AJS	08.07.11
B	D3385-3 WAS D3385-1	MB	05.03.22
A	NEW ISSUE	RF	04.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 1 OF 4
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8 7 6 5 4 3 2 1



D3370-051 PEDAL LOCK ASSEMBLY

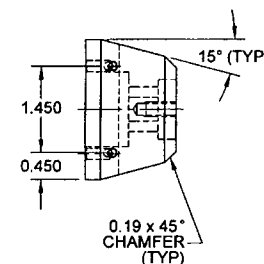
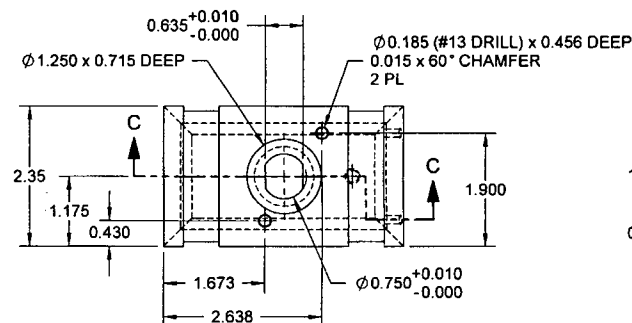
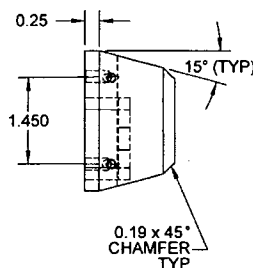
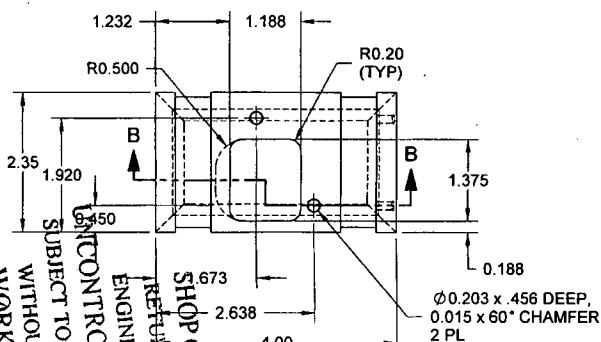
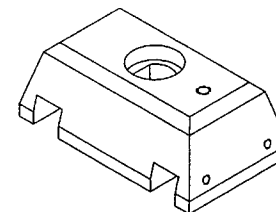
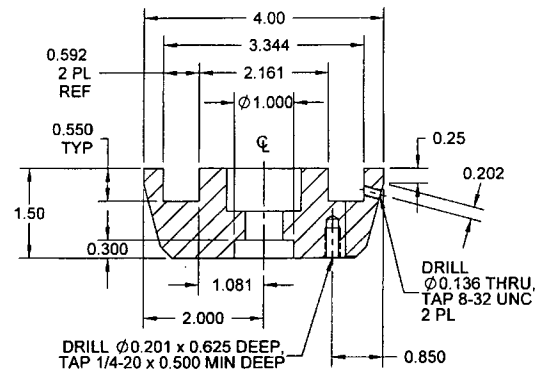
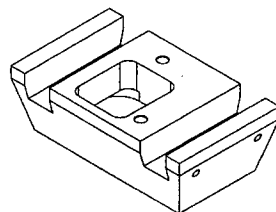
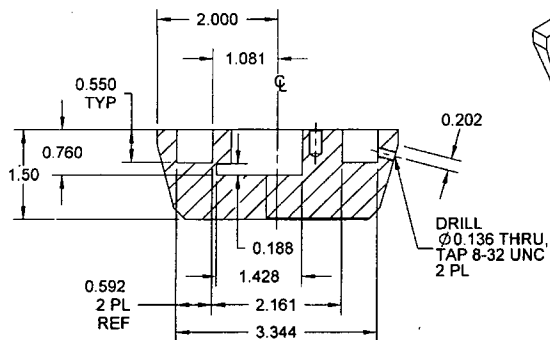


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08-07-11

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.75 lbs

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DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 2 OF 4
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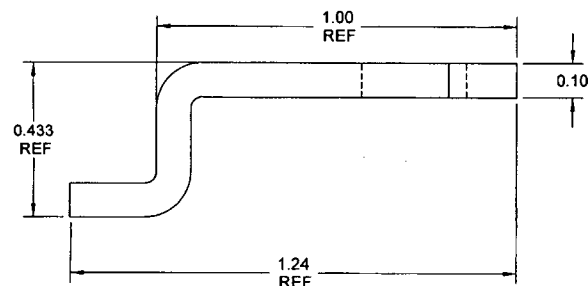
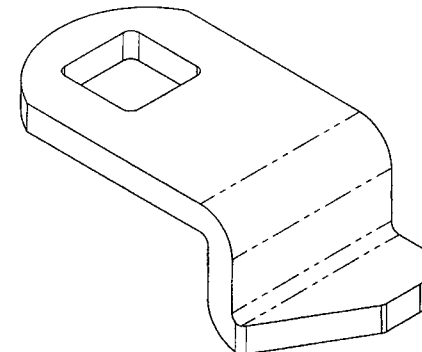
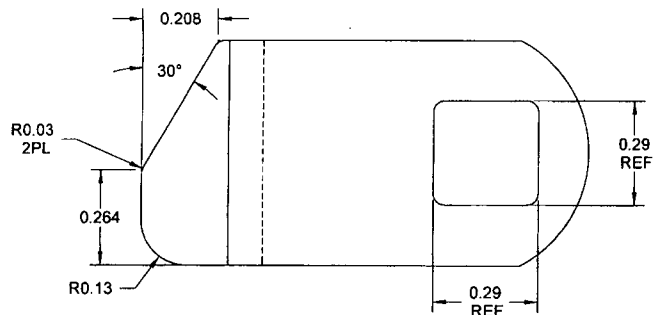
D3370-3 COVER

D3370-1 BASE

- NOTES:
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) REF. DART SPEC. M6061T6B
 - 2) COVER INSIDE HOLES PRIOR PAINTING
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 3 OF 4
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D3370-5 CAM

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WITHOUT NOTICE
WORK ORDER
NO. 4734

- NOTES:
- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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7807-14

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MFG. APPR.		D3370	SHEET 4 OF 4
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